

Date: Tuesday, 4/29/2008 10:17:49 AM
 User: David Duval

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT ASSY (LH)
Job Number : 38872	
Estimate Number : 13285	
P.O. Number :	Part Number : D3699041
This Issue : 4/29/2008 S.O. No. :	Drawing Number : D3699 PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : PRELIM
Previous Run :	Material :
Written By : <u>08/04/30</u>	Due Date : 5/6/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 08-04-25 new issue DD verified by:ec	

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

Job Number:



PRELIMINARY ISSUE

Seq. #: Machine Or Operation: Description :

1.0 M6061T6S050 6061-T6 .050 Sheet



Comment: Qty.: 0.4797 sf(s)/Unit Total : 0.4797 sf(s)
 6061T6 aluminium sheet .050" thick
 (M6061T6S050)
 Batch: 104186 B 8-4-30

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3699
 Dwg Rev: A HB 8-4-30
 Prog Rev: A
 ***grain direction along 9.00" ***
 2- Deburr if necessary LB 8-4-30

①

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/04/30 (XL)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Bend as per Dwg D3697

05-05-01 ①

5.1 counter sink holes as per dwg D3699 FF 08-05-01 ①
08/04/30 5.2 QC5 08/05/01 (XL)

Date: Tuesday, 4/29/2008 10:17:49 AM
User: David Duval

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSY (LH)

Job Number: 38872

Part Number: D3699041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

Sodost07 / 08.05.06 ①

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BK 08-05-07 ①

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M100700

START TIME:

2:45pm

OVEN TEMPERATURE:

3200F

FINISH TIME:

3:15pm

SL 08.05.06 (X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/05/07 (X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

11.0

MS21059L3

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut Plate

batch: *M106042*

✓ ml

12.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rivet

M1563

✓ ml 08/05/09

Date: Tuesday, 4/29/2008 10:17:49 AM
User: David Duval

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSY (LH)

Job Number: 38872

Part Number: D3699041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3699

ml 08/05/09

14.0

QC5

INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

08.05.09 / 08.05.09 (41)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

give to David Duval

FOR KIT B/N 39207

08.05.13

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.05.13 PROTOTYPE

Job Completion



*Charge to
W/O #00235*

U 08.05.13

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-776-011

Job #: 00235

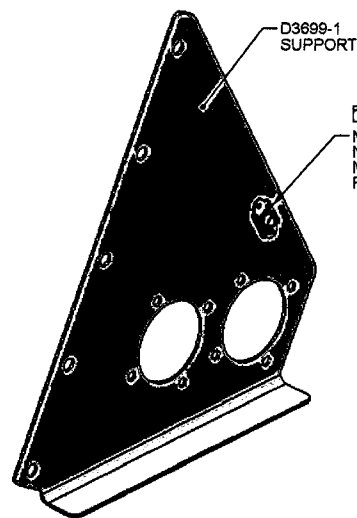
Date: 25-Apr-08

Product Name: B412 Glareshield

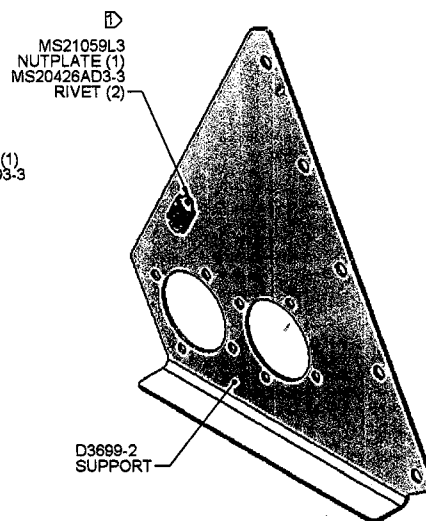
Requested By: MP for RF

Design Manager Approval: 

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3697-1	Tube	31/03/2008	y	09-May-08		
1	D3797-1	Ground Plate	31/03/2008	y	09-May-08		
1	D3697-3	Support Plate LH	31/03/2008	y	09-May-08		
1	D3697-4	Support Plate RH	31/03/2008	y	09-May-08		
1	D3698-1	Support Angle	31/03/2008	y	09-May-08		
1	D3690-1	Glareshield	31/03/2008	y	09-May-08		
1	D3697-041	Tube assy	31/03/2008	y	09-May-08		
1	D3699-041	Support Assy	31/03/2008	y	09-May-08		
1	D3699-042	Support Assy	31/03/2008	y	09-May-08		
1	D3690-041	Glareshield Assy	31/03/2008	y	09-May-08		



D3699-041 SUPPORT ASSEMBLY



D3699-042 SUPPORT ASSEMBLY

PART LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3699-041	SUPPORT ASSEMBLY
	X	D3699-042	SUPPORT ASSEMBLY
1		D3699-1	SUPPORT
	1	D3699-2	SUPPORT
1	1	MS21059L3	NUTPLATE
2	2	MS20426AD3-3	RIVET

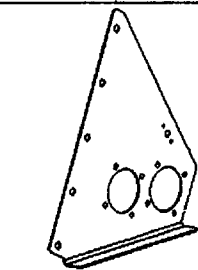
PRELIMINARY ISSUE

08.04.25
[Signature]

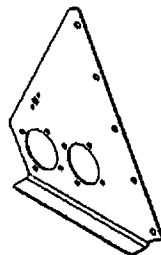
NOTES:

- 1) INSTALL MS21059L3 NUTPLATE USING C'SINK Ø0.098 HOLES ON D3699-1/-2
- 2) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3699-041/-042 & B/N USING FINE POINT PERMANENT INK MARKER
- 3) WEIGHT: 0.17 lb EACH

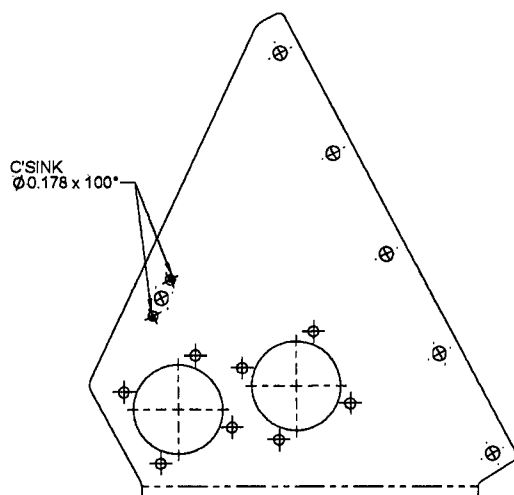
A	NEW ISSUE	RF	08.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3699	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT ASSEMBLY	1:2
DATE	08.03.31	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



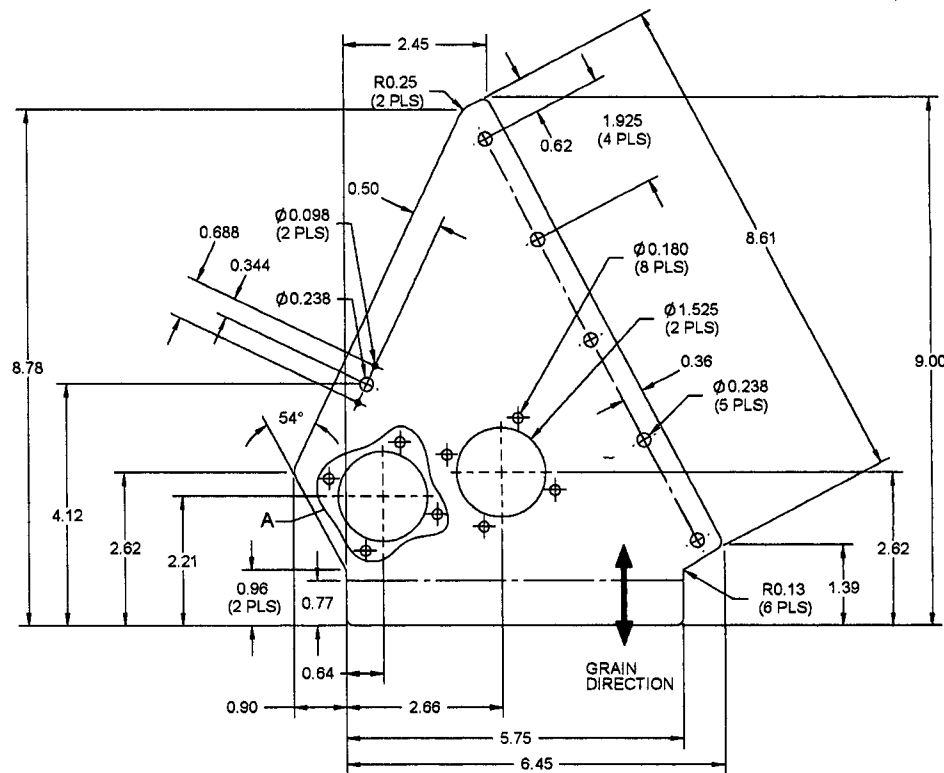
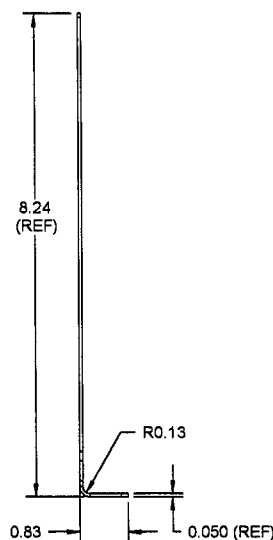
D3699-1 LH SUPPORT



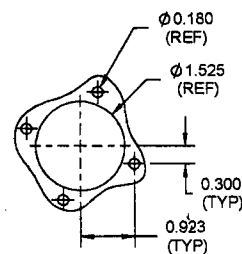
D3699-2 RH SUPPORT



**D3699-1 SUPPORT, LH SHOWN
(D3699-2 SUPPORT, RH OPPOSITE)
(MAKE FROM D3699-1F FLAT PATTERN)**



D3699-1F FLAT PATTERN



DETAIL A

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK
(REF. DART SPEC. M2024T3S.050 OR M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3699	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT ASSEMBLY	1:2
DATE	08.03.31	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	